Thursday, 12/13/2007 2:38:59 PM

User:

Kim Johnston

**Process Sheet** 

**Drawing Name** 

Part Number

**Drawing Number** 

Project Number

**Drawing Revision** 

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 36326

**Estimate Number** 

: 10993

P.O. Number

Prsht Rev.

First Issue

This Issue

Al4:

: 12/13/2007

: NC

MIA

: 34789

Previous Run

Written By Checked & Approved By

Comment

: Est E est F

02.06.17

Type

rev E dwg

: MACHINED PARTS

07.07.06

Now turned on Cobra

S.O. No. : NA

NG

Due Date

Material

: D2579

: CROSSBOLT SPACER

- D2579 REV E : N/A

:NA

: 1/20/2008

Each

**Additional Product** 

Job Number:



Seq. #:

1.0

Machine Or Operation:

M6061T6T0500W058

Description:

6061-T6 Tube .500 x.058W

HARDINGE

Comment: Qty.:

0.3762 f(s)/Unit

Total: 188.1075 f(s)

6061-T6 Tube .500 x.058W

Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4)

0.500 Dia x 0.058 Wall

Batch M106 633 HARDINGE CNC LATHE SMALL

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA245

07/12/22

07/12/22

3.0

4.0

2.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



Comment: SECOND CHECK

PACKAGING 1

QC8

PACKAGING RESOURCE #1

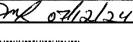
Backer

Comment: PACKAGING RESOURCE #1 Identify and Stock

Location:

07/12/22







Dart Ae	rospace L	td								
W/O:			V	ORK ORDER CH	ANGES					
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	•	PAR #:	Fault Ca	tegory:	NC	_				
NCR:			WORK OR	DER NON-CONFO	RMANCE			u:	Date:	
		Description of NC		Corrective Action	Section B		Vorifie	ation	Annewal	Annaval
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign & Date	Secti		Approval Chief Eng	Approval QC Inspector
				4						

NOTE: Date & initial all entries

Daţe:

Thursday, 12/13/2007 2:38:59 PM

Uşer:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 36326

Part Number: D2579

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE







Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2008/112

Dart Ae	rospace	Ltd							
W/O:			WO	RK ORDER CHAN	NGES				
DATE	STEP	PRO	OCEDURE CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA	۸:	_ Date: _	
					QA: N	/C Closed	l:	_ Date: _	
NCR:			WORK ORDE	R NON-CONFOR	MANCE (NCF	(1)			
		Description of NC	C	Corrective Action S	Section B	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descriptio Chief Eng	n Sign 8 Date	Section		Chief Eng	QC Inspector

NOIK.			· ·								
		Description of NC		Corrective Action Section B	Verification	Approval Chief Eng	Approval QC Inspector				
DATE	STEP	Section A	Initial Action Description Sign 8 Chief Eng Chief Eng Date		Sign & Date			Section C			
		,									
		\$ )									
					-3						

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36326
Description: Cross Bolt Spacer	Part Number:	D2579
Inspection Dwg: D2579 Rev: E		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.070	+/-0.030	4.070	<b>V</b>			
0.058	+/-0.010	-057	~			
		,				
		1				
					<u></u>	

Measured by:	H.A/82	Audited by:	And	Prototype Approval:	N/A
Date:	07/12/22	Date:	07/12/122	Date:	N/A

Rev	Date	Change	Revised by Ap	proved
Α	03.11.27	New Issue	KJ/RF	
В	07.09.06	Dwg Rev updated	KJ/JLM	E
-		· · · · · · · · · · · · · · · · · · ·	7()	



DESIG	H #	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED 11	APPROVED	DRAWING NO. REV. E
	一树	1	D2579 SHEET 1 OF 1
DATE			TITLE SCALE
07.0	04.17		CROSS BOLT SPACER 1:1
Α		96.09.16	NEW ISSUE
В		96.12.05	0.065 WALL WAS 0.035 WALL
C		97.02.21	0.058 WALL WAS 0.065 WALL
D		99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)

UPDATE NOTES



	4.070±0.030
Ø0.500 Ø0.384 (REF)	

07.04.17

## D2579 CROSS BOLT SPACER

Ε

## D2579 CROSS BOLT SPACER

MATERIAL:

6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8

(REF DART SPEC M6061T6T0500W058)

2) FINISH: NONE

0.058

3) ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RETURN TO ENGINEERING

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